DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028984
Date Inspected: 11-Jan-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	As noted below.			**CWI Present:**	☑ Yes	☐ No		
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: Tower

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Approximately 7:00am this QA attended a meeting with ABF, Quality Control (QC), and QA personnel to discuss Ultrasonic Testing of tower shear plate electroslag welds. This QA was informed that two (2) teams of tandem QA/QC inspectors would be performing UT per the supplemental procedure SE-UT-D1. 5-CT-108-ESW-R5. Discussed during this meeting were methods for establishing (x) coordinates of indications found on butt welds with mis-matched thicknesses. (ie. 80mm to 100mm)

Also discussed during this meeting was the process to be followed in performing tandem inspection and the estimated amount of completed inspection per shift.

Ultrasonic Testing of ESW
ESW P, Face A:

This QA performed Ultrasonic Testing (UT) on approximately 900mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as “ESW P” face A. Location (Y=5800~6700) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This QA observed one recordable indication at the time of testing. (Listed below)

This QA generated a TL-6027 UT report on this date.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or “X” location.

Indication #1: Y= 6080mm
Sizing – A=72db, B= 51db, C= 8db, D= 13db
L= 30mm, X= -15mm
Sound Path= 131mm, Depth= 45mm

This QA performed UT of weld designated as ESW P in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Jesse Cayabyab. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Due to QA/QC disagreement on indication interpretation, tandem report may not reflect all indications discovered by QA at time of testing. Please see TL-6027 for complete listing of QA recorded indications.

As per direction of QA Level III Robert Mertz this QA performed information only UT of ESW T, face A, at (Y= 7000mm~8000mm). This UT was performed to ascertain the existance of one (1) class A rejectable planar type indication. This QA could not locate the indication in question at time of testing. Upon review, the prescribed "Y" location was called in to question and testing was called off until "Y" location could be verified.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation as stated above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer